Dart Aerospace Ltd.

Date: Friday, 1/20/2006 7:39:13 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: D206547041/043/045 /047
Job Number	: 25575		
Estimate Number	: 10804		
P.O. Number	: N/A	**Part Number**	: Z_CUSTOM
This Issue	: 1/20/2006 **S.O. No.** : N/A	**Drawing Number**	: CHANGE P/N & LABELS
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: 1/19/2006 **Type** : N/A	**Drawing Revision**	: N/A
Previous Run	: 00015	**Material**	: N/A
Written By	: SEE ABOVE DATE & USER	**Due Date**	: 1/26/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: SEE ABOVE DATE & USER		
Comment	:		

Additional Product

Close for 0
have already done
adj
LL

Job Number:

Seq. #:	**Machine Or Operation:**
1.0	PACKAGING 1 PACKAGI

Comment: PACKAGING RESOURCE #1
REMOVE FROM STOCK ALL D206-547'S AND RECORD BATCHES

D206-547-041 B17452 X35 B25579 36 mcq D206547-11
B15657 X 5 = D206-547-11 B23308

D206-547-043 B23273 X7

D206-547-045 B17291 X25 = D206-547-11 (X7) B23308 / D206-547-11 B25579 18 m...
B4678 X 5 = D206-547-11 B23308
B7332 X 1 = D206-547-11 B23308

D407-547-047 B22642 X 5 B21908 X 2 B9755 X 1 = D206-547-11 B23308

2.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
REMOVE ALL 547 LABELS (RED & WHITE) AND REPLACE WITH 549 LABELS PER ATTACHED - KEEP SAME BATCH NUMBERS

Form: rprocess

Date: Friday, 1/20/2006 7:39:13 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd. **Drawing Name:** D206547041/043/045

Job Number: 25575 **Part Number:** Z_CUSTOM

Job Number:

Seq. #:	Machine Or Operation:	Description :
3.0	D20654711	Angle, Console

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Angle, Console
add 2 x D206-547-11 B_25575
to boxes that are missing these parts per NCR 6/2/6 (53)

Seq. #:	Machine Or Operation:	Description :
4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
ENSURE ALL LABELS AND BATCHES MATCH
AND REPACKAGE PER PPP 6/2/6 (53)

Seq. #:	Machine Or Operation:	Description :
5.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL 06/02/09 06/02/09

Job Completion

Form: rprocess

W+R

045 015 — B17291 ✓ 25mc

B4678 ✓ 5mcg — (31)

7332 1mcg

047 017 — B22642 ✓ 5mcg

B21908 ✓ 2mcg — (8)

B9755 ✓ 1mcg

043 013 — B23273 ✓ 1mcg — ([illegible])

([illegible])

41 011 — B17452 ✓ 25mcg — ([illegible])

B15657 ✓ 5mcg — (40)

Manufacturing Project Plan Sheet ____ of ____

New Proj ____ Rev Proj ____ MPP No. 2297 ECN No. N/A Prep'd By [signature] Date 06·01·05

Release Date for Project 06·01·05 Note: D206-549 Console

Production Actions (N/A for new project from Eng.)	Yes	No	Authorization	to happen by:	completed	Date
Re-Work Current Stock -kits	✓	✓	XXXXXXX			
Re-Work Current Stock -paperwork		✓	XXXXXXX			
Re-Work Current Production		✓	XXXXXXX			
Re-Work Current Production W/O	✓	✓	XXXXXXX			
Re-Work Current Production STC Paperwork		✓	XXXXXXX			
Scrap Current Stock		✓				
Notify Customers		✓				
Notify Marketing		✓	XXXXXXX			

Considerations for Future Prod'n	Yes	No	Authorization	to happen by:	completed	Date
IPP	✓		XXXXXXX		[signature]	05·01·05
Inspection/Dimension sheet		✓				
Tooling		✓	XXXXXXX			
Programming		✓				
BOM ~~in MIS~~ Coss	✓		XXXXXXX		[signature]	05·01·05
QSI 014		✓	XXXXXXX			
Manufacturability		✓	XXXXXXX			

Tasks:	Responsible	Complete By	Complete	Date
1- Update Estimates in Coss. Reflecting. D206-549.	SLM	06·01·13	[signature]	05·01·05
2- Assign CHG number To (CHG 002) D206-549-011-013-015-017.	KS.	06·01·13	[initials]	06.01.06
3- Update PPP's FOR D206-549-011-013-015-017.	KS.	06·01·13	[initials]	06.01.06
4- Update All Kits in Stock with -549 Labels & Decals	LL			
5- Update Current WIP	LL.			

QA Actions				
Release Documents				

Project Complete ________ Date ________

25.2 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-549-011	2 lbs 0.907 kg	0 in 0 m	0 lbs-in 0 kg-m	48.0 in 1.22 m	96.00 lbs-in 1.11 kg-m
D206-549-013	2 lbs 0.907 kg	0 in 0 m	0 lbs-in 0 kg-m	48.0 in 1.22 m	96.00 lbs-in 1.11 kg-m
D407-549-015	2 lbs 0.907 kg	0 in 0 m	0 lbs-in 0 kg-m	48.0 in 1.22 m	96.00 lbs-in 1.11 kg-m
D407-549-017	2 lbs 0.907 kg	0 in 0 m	0 lbs-in 0 kg-m	48.0 in 1.22 m	96.00 lbs-in 1.11 kg-m

25.3 PARTS LIST

For convenience, only the last three digits of the Part No. are listed on the top row of each table. The quantity of each component which is included in the D206-549-011 Avionics Console installation, for example, is as defined in the column labeled -011.

-011	-013	-015	-017	Part Number	Description
X				**D206-549-011**	**LOW SLOPE CONSOLE INSTALLATION, 206**
	X			**D206-549-013**	**HIGH SLOPE CONSOLE INSTALLATION, 206**
		X		**D407-549-015**	**LOW SLOPE CONSOLE INSTALLATION, 407**
			X	**D407-549-017**	**HIGH SLOPE CONSOLE INSTALLATION, 407**
REF	REF	REF	REF	D1038-58	FASTENER RAIL
REF	REF	REF	REF	D1038-58B	FASTENER RAIL, BLACK
1	1	1	1	D2163	CAP ANGLE
1				~~D206-547-041~~	206 LOW SLOPE CONSOLE ASSEMBLY
	1			~~D206-547-043~~	206 HIGH SLOPE CONSOLE ASSEMBLY
		1		D407-547-045	407 LOW SLOPE CONSOLE ASSEMBLY
			1	D407-547-047	407 HIGH SLOPE CONSOLE ASSEMBLY
2	2	2	2	D206-547-11	ANGLE
28	28	28	28	MS20470AD4-5	RIVET
14	14	16	16	AN960JD10L	WASHER
14	14	16	16	MS27039-1-08	SCREW

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	RF	
CHECKED	APPROVED	DRAWING NO. D206-547 — REV. F — SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY — SCALE NTS

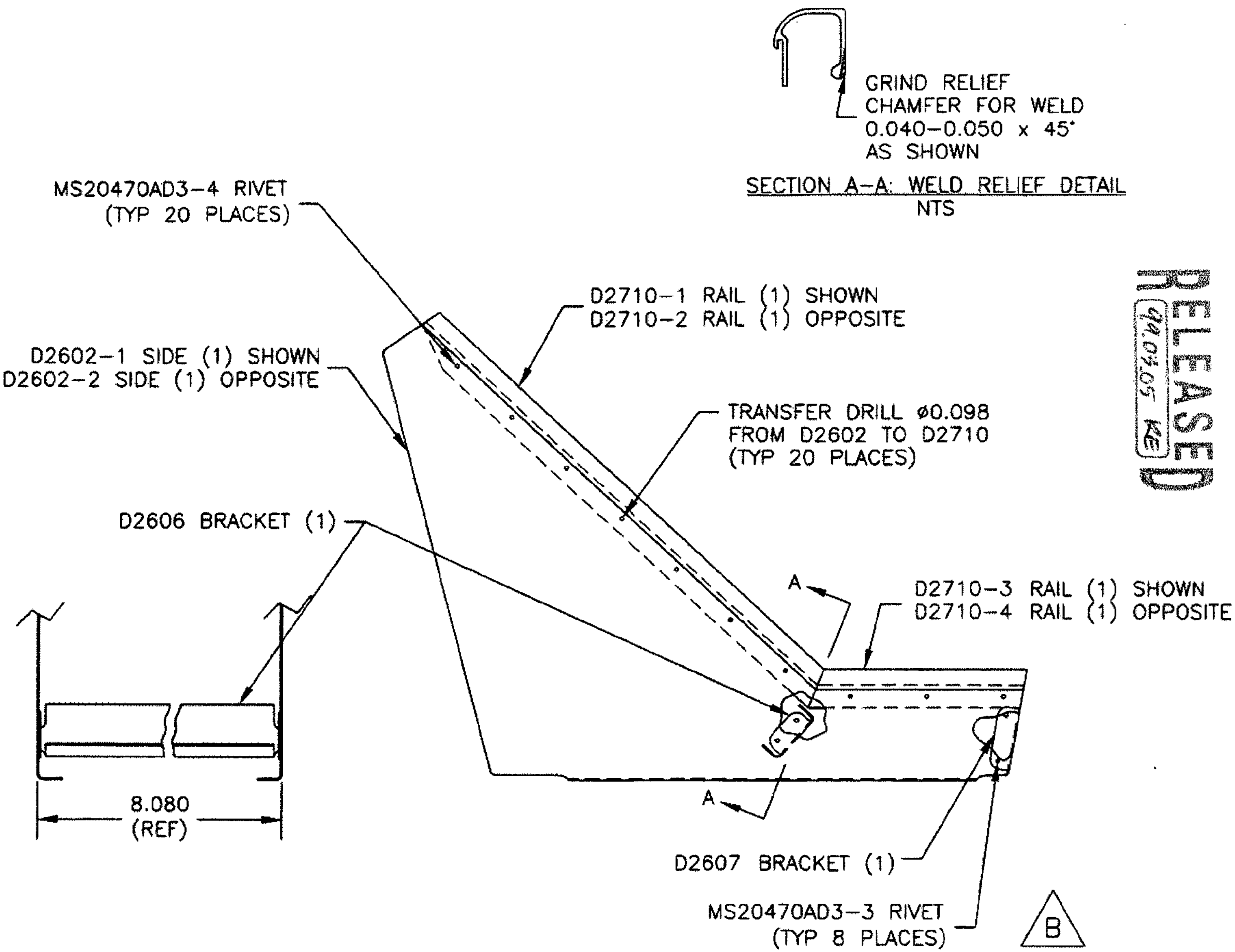
DART

QA COPY ISSUED

RELEASED 99.03.05 RE

REV	DATE	DESCRIPTION
–	82.11.23	NEW ISSUE
A	83.01.18	REDRAWN, ADD NOTE 4
B	84.10.23	D206-547 WAS 01.B.81.017
C	89.03.30	REDRAWN
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85
E	97.10.22	REDRAWN, ADD -043,-045,-047
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				**D206-547-041**	**CONSOLE ASSEMBLY**
	X			**D206-547-043**	**CONSOLE ASSEMBLY**
		X		**D407-547-045**	**CONSOLE ASSEMBLY**
			X	**D407-547-047**	**CONSOLE ASSEMBLY**
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET



D206-547-043 (206 HIGH SLOPE CONSOLE)

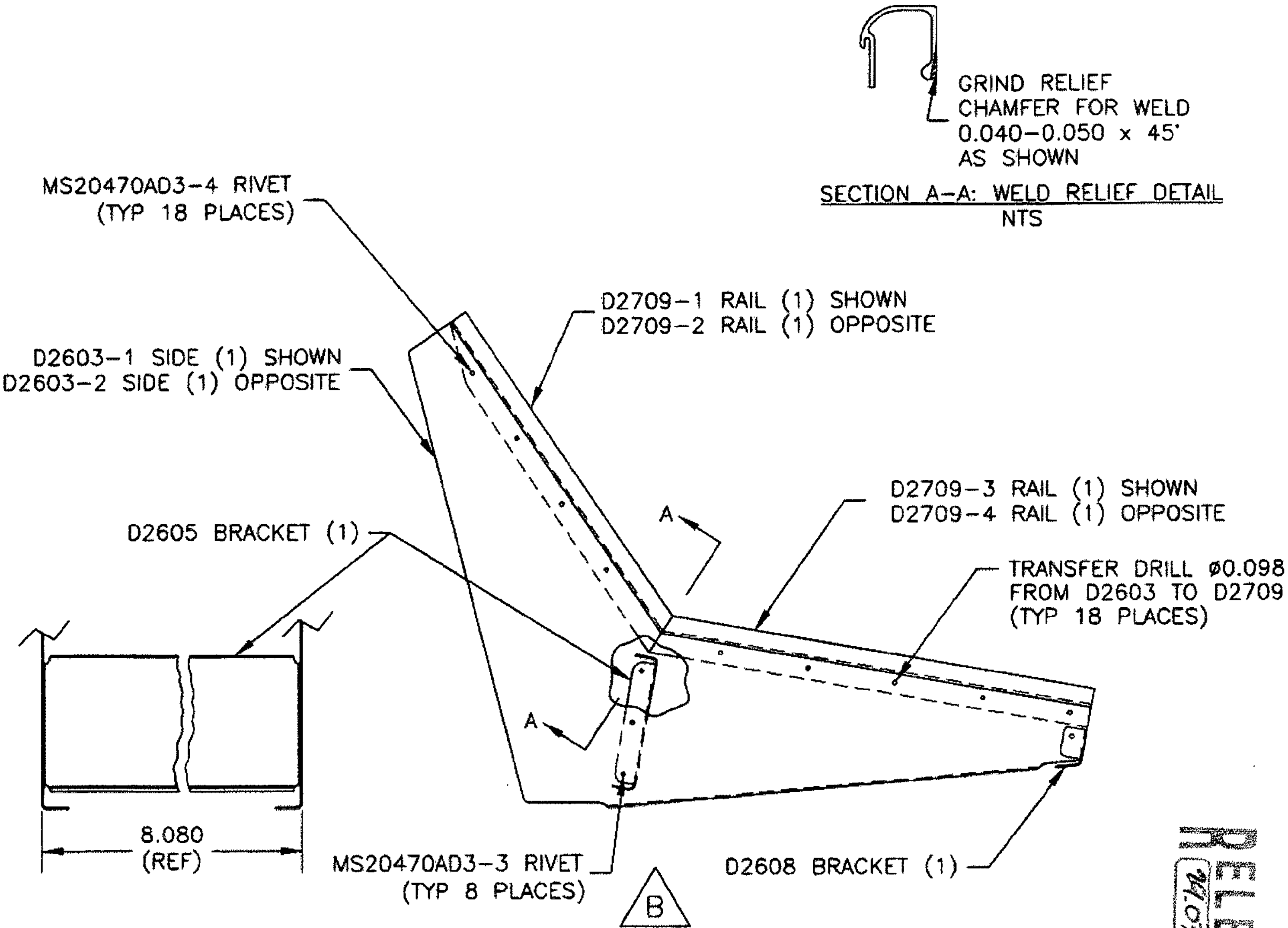
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	DRAWN BY	DRAWING NO.	REV. F
BW	RF	D206-547	SHEET 3 OF 5
CHECKED	APPROVED	TITLE	SCALE
[illegible]	KE	CONSOLE ASSEMBLY	1:4
DATE 99.02.11			



D407–547–045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

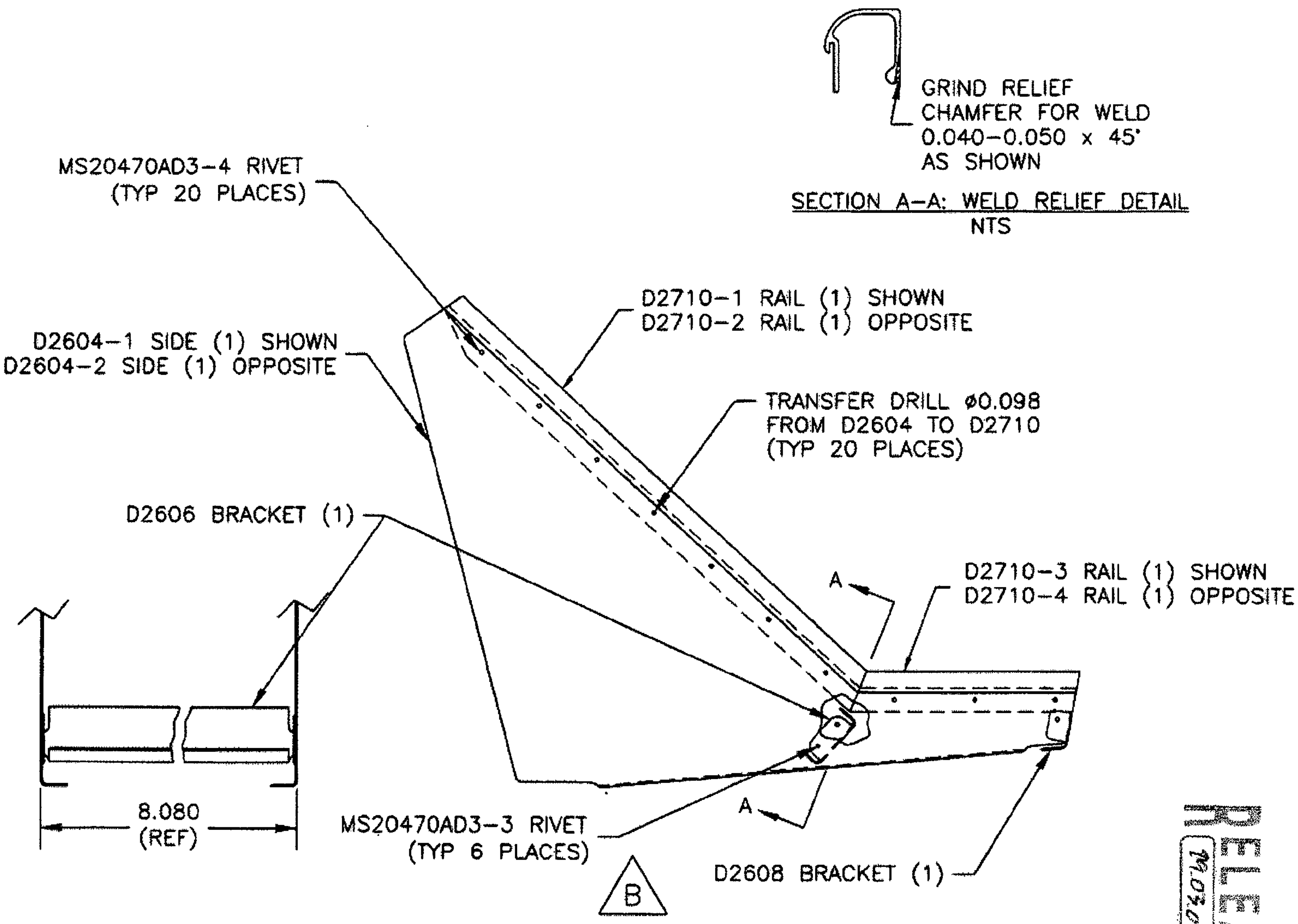
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BW	RF
CHECKED	APPROVED
DATE 99.02.11	

DRAWING NO. D206-547 REV. F
TITLE CONSOLE ASSEMBLY
SHEET 4 OF 5
SCALE 1:4



D407–547–047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

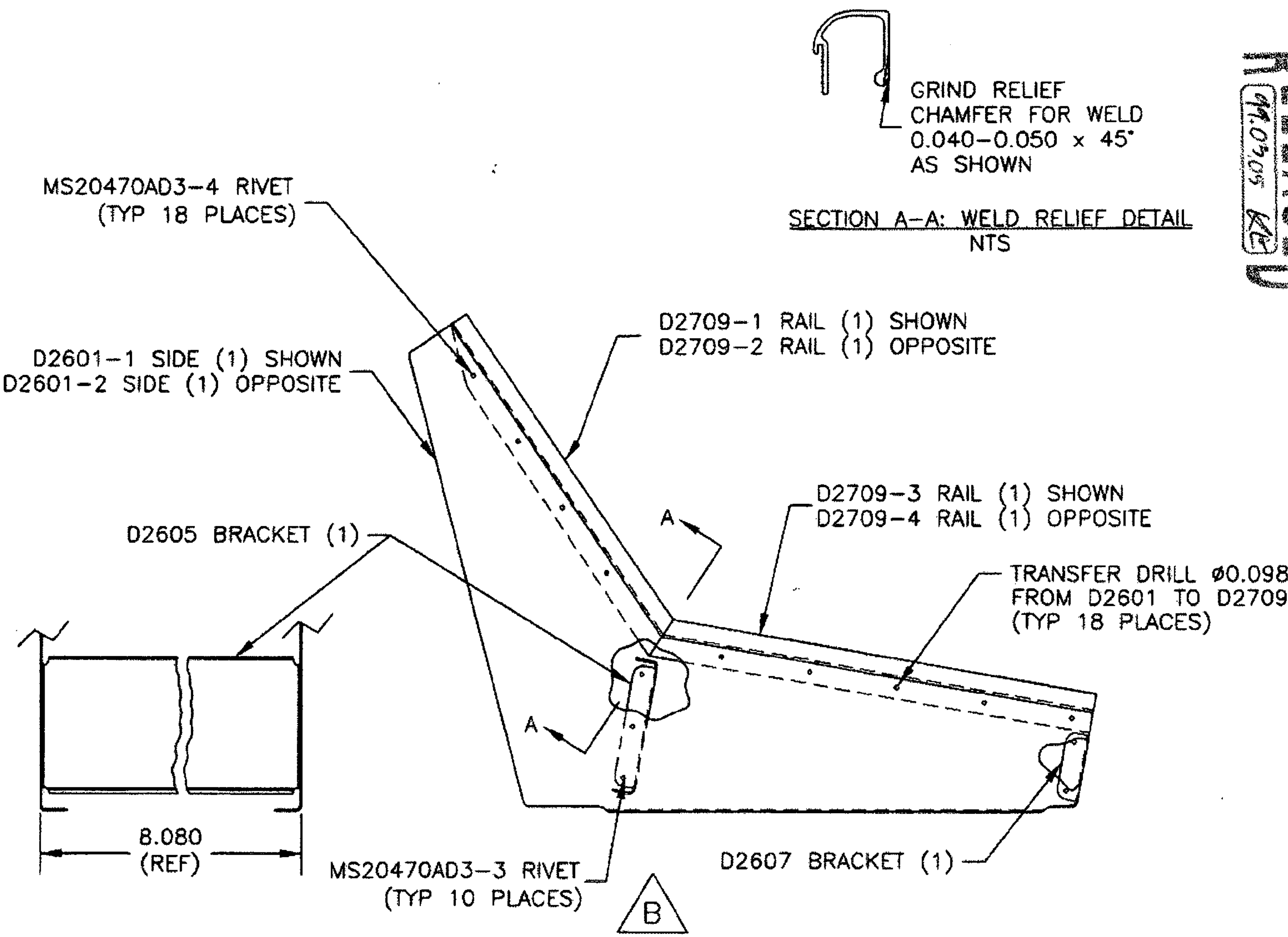
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DESIGN	BW	DRAWN BY	RF
CHECKED	UP	APPROVED	KE
DATE	99.02.11		

DRAWING NO. D206–547 REV. F
SHEET 5 OF 5
TITLE CONSOLE ASSEMBLY
SCALE 1:4



RELEASED 99.09.05 KE

D206–547–041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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BW	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
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DATE 99.02.11		TITLE CONSOLE ASSEMBLY — SCALE 1:4